



Dart Aerospace Ltd.
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D3913-041
Job Sheet 195014



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	6/20/19		0.00	19.61	Large Fab - 1		SEP 1 8 2019
							Large Fab - 10		
							Large Fab - 2	DAS 24	
							Large Fab - 3	9-89	
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	6/20/19		0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	6/20/19		0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



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Container No: S214857



Part: D3913-041

Job No: 195014

Serial No/Batch: S214857

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/18/19

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						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	6/20/19	0.00	0.29	Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	BK 19-9-24.
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	6/20/19	0.00	0.93	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BK 19-9-24.
						Powdercoat - 4 - B4B	
140	QC 3	1 pcs	6/20/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	BEB 19-09-25
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	6/20/19	0.00	0.50	Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	BEB 19-09-26
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	

DAS
59
0.80

				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
160 QC 5	1 pcs	6/20/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
170 Packaging 3-1 - Stock - B4B	1 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
180 QC 21 - SA	1 pcs	6/20/19	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70		

DAS
SEP 26 2019 40
9:00

BEB 19-09-26

DAS
21 SEP 26 2019
9:00

QC 21 - SA - 53

Part Op 100 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5108 852
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5209116
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5184 576
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5189 078
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5197 553
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5190 823
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5210 886
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5203 884
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5188 922
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5183 658
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5197 557
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5205 482
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5192 406
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5204 825
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5197 575
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5210 214
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5188 431
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5216 929
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5864 35
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5202 554
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5204 283-2
NAS1149F0332P	Washer	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5216 748
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5188 988
NAS1149FN832P	Washer	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136 368

Pass allocated

M.U. 012105

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	28	0
	D3913-1	1	13	0
	D3913-15	1	6	0
	D3913-3	1	7	0
	D3913-7	2	30	0
	D3913-9	1	12	0
	D3916-041	2	9	0
	D3916-5	3	22	0
	D4016-1	3	36	0
	D4017-7	3	58	0
	D4017-9	2	10	0
	D4020-11	2	14	0
	D4021-1	3	36	0
	D4034-041	1	2	0
	D4034-043	1	2	0
	D4672-1	2	13	0
	M304EX0.75-16F	32	717	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	345	0
	D2931	2	723	0
	D4021-5	2	22	0
	MS20600-AD4W3	2	364	0
	MS21042L3	6	2,855	0
	NAS1149F0332P	12	4,629	0
	NAS1149FN832P	2	2,329	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐
Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐
Bending ☐ ☐ ☐
Crushing ☐ ☐ ☐
Cracks ☐ ☐ ☐
Crimp/kink/Ripple/Wave/Twist ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐
Mislabeled ☐ ☐ ☐
Contamination ☐ ☐ ☐
Misaligned/off center ☐ ☐ ☐
BOM/Route ☐ ☐ ☐
Broken/Damage/Defect ☐ ☐ ☐
Incomplete/Unclear Instructions ☐ ☐ ☐
Drill Holes ☐ ☐ ☐
Fit/Function ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐
Folio/Program ☐ ☐ ☐
Grain Direction ☐ ☐ ☐
Weld ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐
Positioned Wrong ☐ ☐ ☐
Outside Tolerance ☐ ☐ ☐
Drawing ☐ ☐ ☐
Finish ☐ ☐ ☐
Part Lost/Missing ☐ ☐ ☐
Misread ☐ ☐ ☐

Other/Details: _____